



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D350-578-011
Job Sheet 180833



004493

Part No: D350-578-011

Job Qty: 4 ea

Part Name: AS350/AS355 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/26/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV H SHEET 12 IPP Rev:A New Issue 07-01-02 JLM IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	4 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Stores/Pkg-2		
160	Packaging	4 pcs	7/26/18	7/26/18	0.00	0.00	Packaging1-3		
170	QC	4 pcs	7/26/18	7/26/18	0.00	0.00	QC4		
180	Packaging	4 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3-1		
185	DC	4 pcs	7/26/18	7/26/18	0.00	0.00	DC		
190	QC21-FG	4 Ea	7/26/18	7/26/18	0.00	0.00	QC21		

JUL 18 2018

Sign-off

JUL 19 2018

JUL 19 2018

Smb
Smb

21
JUL 23 2018

fg013

Part Op 180 - Identify and pack for shipping per PPP D350-578-011 CHG006
Descriptions: 185 - Photocopy bluefile and create

Job BOM

Part / Item	Component	Quantity	Operation	Container
AN4-16A	Bear paw 19" X 24"	48 Ea (12 ea)	90-Start up Operation	5082909
D2432		8 Ea (2 ea)	90-Start up Operation	5069187
D2529	Washer	48 Ea (12 ea)	90-Start up Operation	5035698
D3601-1	Radius Block	48 Ea (12 ea)	90-Start up Operation	5077169
D4011-1	Clamp, Short	24 Ea (6 ea)	90-Start up Operation	5067468
D4012-1	Cushion	24 Ea (6 ea)	90-Start up Operation	5044252
MS21042L4	Nut	48 Ea (12 ea)	90-Start up Operation	5089365
NAS1149D0463J	Washer	96 Ea (24 ea)	90-Start up Operation	5062379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-16A	48	269	0
	D2432	8	22	0
	D2529	48	1,597	0
	D3601-1	48	124	0
	D4011-1	24	158	0
	D4012-1	24	335	0
	MS21042L4	48	3,835	0
	NAS1149D0463J	96	7,044	0

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Compos ☐
Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

Work Order: _____
Part No. _____
NCR No. _____

Date: _____

Step #: _____

QTY Effective: _____

Description Work Order Deviation

Position

Completed By

MRB (QS1042) Approval

hand / Supervisor
roval Verification

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www.dartaerospace.com

Date: 07/18/18

Root Cause

Environment ☐
Design ☐
Doc/Data ☐
Equip/Tooling ☐
Handling/Pre ☐
Material ☐
Internal Transport ☐
Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐
No Re-verification ☐
Operator ☐
Offset/Setup ☐
Supplier ☐
Training ☐
Use for Testing ☐
Poor Information ☐
Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Pressure/
Bending
Centre No
Cracks
Crimp/Kinl
Cuffs
Crushing
Heat Treat
Wave/Twist in tube
Marks/Chatter



Container No: S093420
Part: D350-578-011
Job No: 180833
Serial No/Batch: S093420

Revision:
Inspector:
Exp Date:
Instructions:

Instructions Incomplete/Unclear
Drill Holes

Misaligned
Fit/Function
Misaligned/off center

Finish ☐
Misread ☐
Turning Sequence ☐

OTHER:

Part Specifications
Specifications could not be found.

Plex 7/17/18 10:20 AM dart.lacelle.linda

REFERENCE ONLY

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit

REFERENCE ONLY

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Revision: H

Date: 15.03.12

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Part Number: D350-578-011

[illegible]